

Date: Wednesday, 2/20/2008 4:24:49 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CABLE GUARD
Job Number : 37554	
Estimate Number : 12457	
P.O. Number :	Part Number : D29163
This Issue : 2/20/2008 S.O. No. :	Drawing Number : D2916 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 27905	Material :
Written By :	Due Date : 3/5/2008 Qty: 4 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev:A New Issue 06-06-19 JLM	
Est Rev:B Now water jet 06-07-14 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 0.5775 sf(s)/Unit Total : 2.3100 sf(s)  
UHMW 1" Black  
batch: 107067 RB 8-2-25

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Dwg D2916  
Dwg Rev: B RB 8-2-25  
Prog Rev: B

(4)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

BATCH: 107067

1- Mill as per Folio FA2916-3 Rev: A & Dwg D2916 Rev: B

2-Deburr per dwg D2916

J.L 08/03/05

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2916-3 PAR #: N/A Fault Category: Prod / Machined Parts NCR: (Yes) No DQA: 2 Date: 08/03/12  
 QA: N/C Closed: 4 Date: 08/03/12

NCR: <u>37554</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/03/05</u>	<u>4.0</u>	<u>- 2 parts are scrapped</u> <u>Both parts</u> <u>and end</u> lifted while machining and counter bore went thru <u>R.C. poor tooling</u>	<u>[Signature]</u>	<u>- scrap &amp; destroy and</u> <u>Revolve BA M107067</u> <u>Qty (12)</u>	<u>J.L.</u> <u>08/03/05</u>	<u>[Signature]</u> <u>08/03/11</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>08/03/05</u>

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:24:49 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABLE GUARD

Job Number: 37554

Part Number: D29163

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L. / KA 08/03/07

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 08/03/11 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

LC 3/50 (4)

8.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

RD 08/03/12 (4)

Job Completion



mi 2008/3/11 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

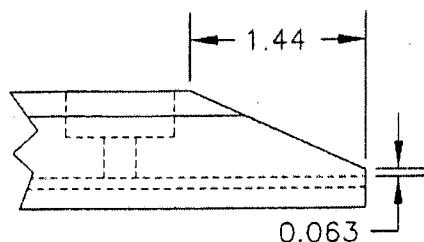
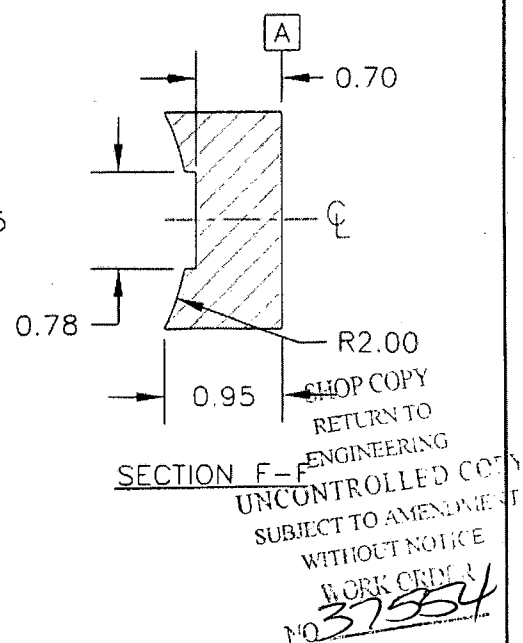
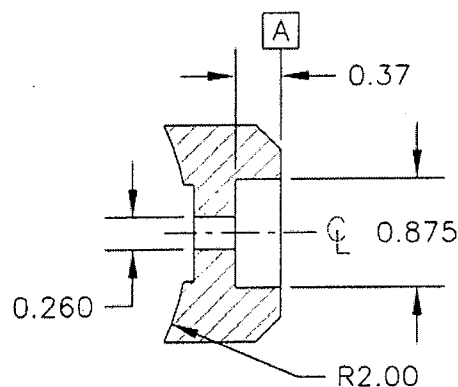
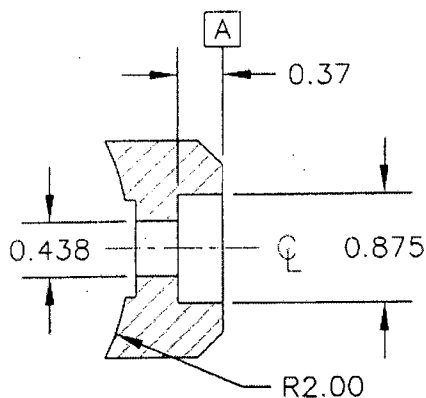
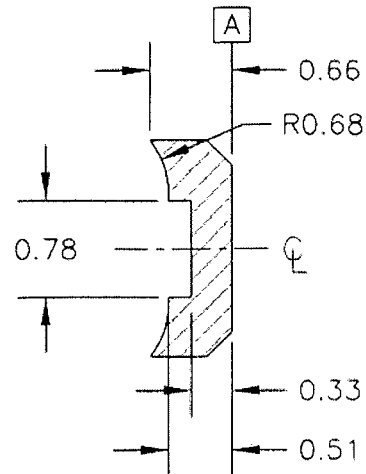
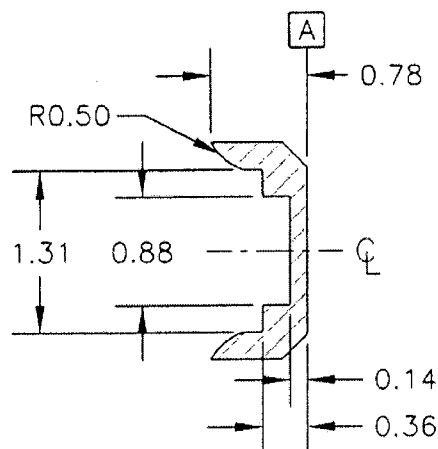
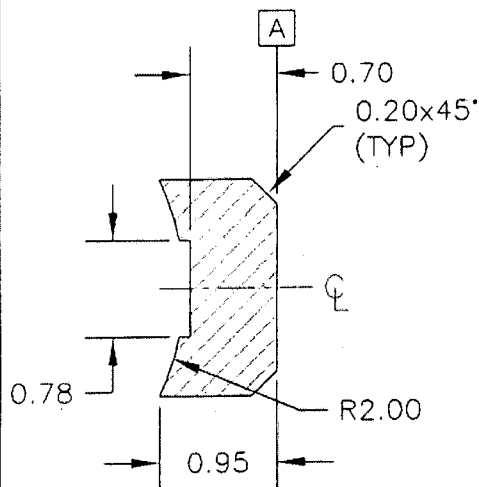
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



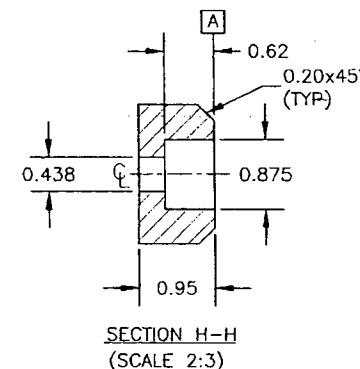
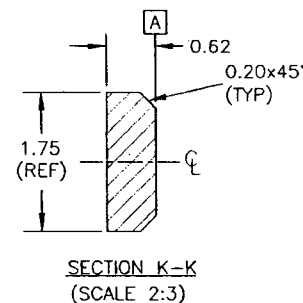
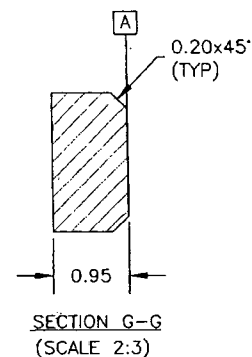
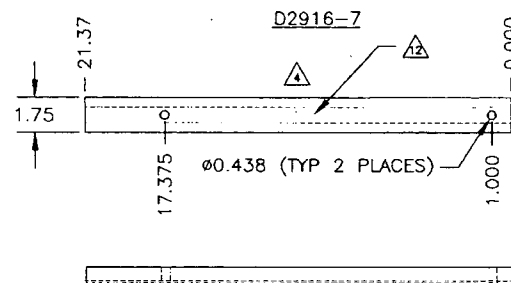
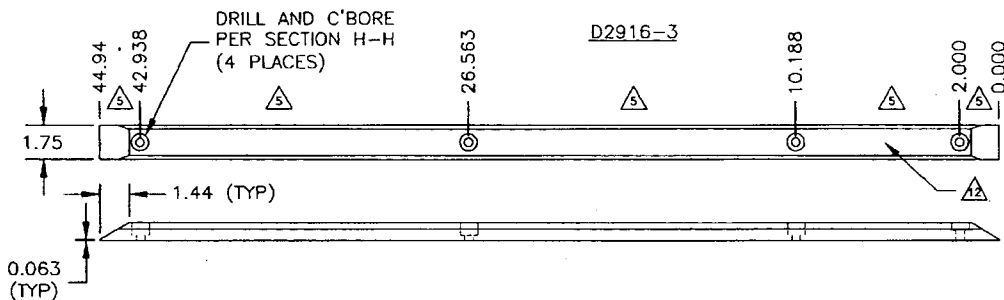
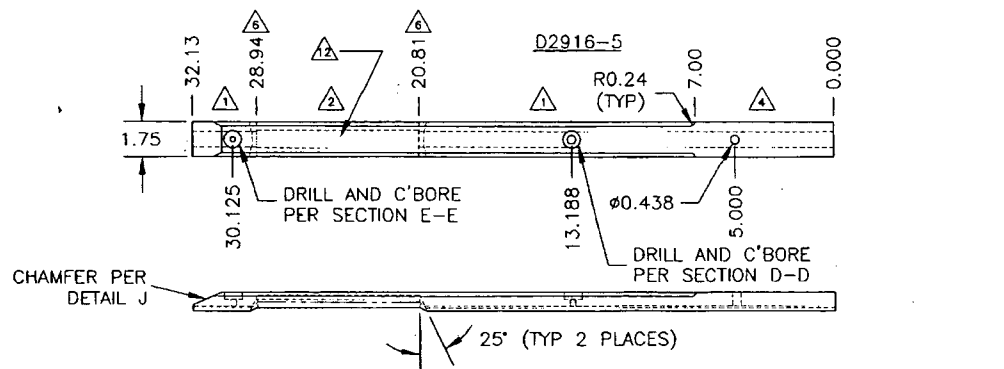


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2916	REV. B SHEET 1 OF 2
DATE 00.02.24		TITLE CABLE GUARD	SCALE 1:6
A	99.09.29	NEW ISSUE	
B	00.02.24	ADD K-K FOR D2521 COMPATIBILITY	



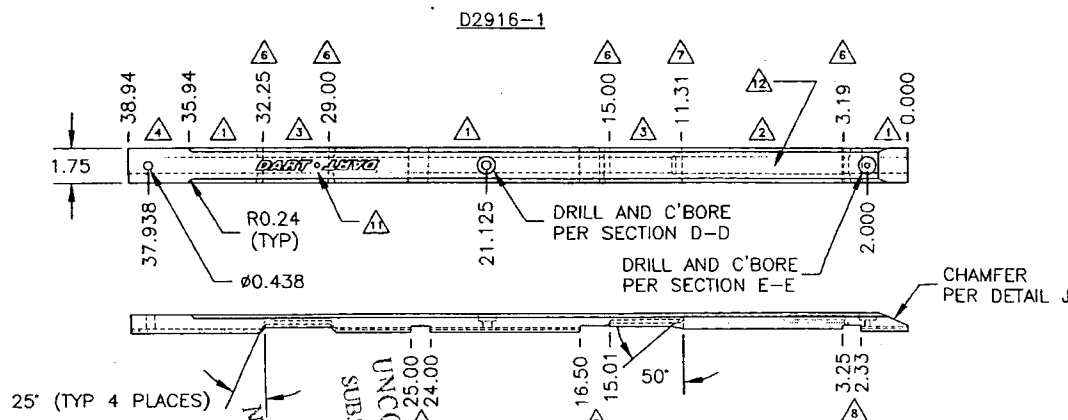
DETAIL J  
(SCALE 2:3)

RELEASED  
00.02.25 DS



#### NOTES:

- 1) MACHINE CONSTANT SECTION A-A
- 2) MACHINE CONSTANT SECTION B-B
- 3) MACHINE CONSTANT SECTION C-C
- 4) MACHINE CONSTANT SECTION F-F
- 5) MACHINE CONSTANT SECTION G-G
- 6) 25° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 7) 50° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 8) MACHINE SLOT PER SECTION K-K WITH 0.063 RADIUS OF TRANSITION BETWEEN SECTIONS
- 9) MATERIAL: UHMW BLACK PER SPEC CONTROL DWG D2689
- 10) BREAK ALL UNMARKED RADII 0.020 TO 0.040
- 11) ENGRAVE TWO DART LOGOS (OPPOSITE AS SHOWN) ON UPPER SIDE TO MAX DEPTH OF 0.015 AND MIN RADIUS OF 0.250.
- 12) ENGRAVE P/N ON LOWER SIDE TO MAX DEPTH OF 0.010 AND MIN RADIUS OF 0.010.
- 13) ALL HOLES DRILLED ON CENTERLINES
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 15) ALL DIMENSIONS ARE IN INCHES



RELEASED

DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD HAMMERSLEY, ONTARIO, CANADA	REV. B
CHECKED	APPROVED	DRAWING NO. D2916	SHEET 2 OF 2
DATE 00.02.24		TITLE CABLE GUARD	SCALE 1:6

NO. 37804  
WORK ORDER  
WITHOUT NOTICE  
UNCONTROLLED COPY  
RETURN TO  
ENGINEERING  
00.02.24  
00.02.24